



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D350-591-122
Job Sheet 201854-A



Part No: D350-591-122

Job Qty: 3 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Due Date: 11/29/19

Created By: Eric Larocque

Type: Stock

Description:

Note: DWG D2351-042 REV E, IIN-D350-591 REV H IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC 5	3 pcs	11/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
140	Large Fab - Welded Assy-2-B4B	3 pcs	11/29/19		0.00	2.50	Large Fab - 1 - B4B		Sla
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		



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Container No: S229982



Part: D350-591-122

Job No: 201854-A

Serial No/Batch: S229503

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH96

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				Large Fab - 12 - B4B	
150 QC 9	3 pcs	11/29/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	EL
				QC 9 - 9	
160 QC 5	3 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	3 pcs	11/29/19	0.00 0.30	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	EL NOV 11 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	3 pcs	11/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	

					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	DAS NOV 11 2019 68
					QC 7 - 50	9-89
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
190	Large Fab - Welded Assy-3-B4B	3 pcs	11/29/19	0.00 2.40	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
220	QC 10	3 pcs	11/29/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS 24
					QC 10 - 43	9-89
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	
230	QC 5	3 pcs	11/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS 24
					QC 5 - 43	9-89
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	

240 Handfinish - 1-2- Chemical-B4B	3 pcs	11/29/19	0.00 0.56	QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	BEB 19-11-12.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
250 Powdercoat - 1 White Gl(A)-B4B	3 pcs	11/29/19	0.00 0.62	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 19-11-12
				Powdercoat - 4 - B4B	
260 Handfinish - 3-1- WingWalk-B4B	3 pcs	11/29/19	0.00 0.56	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	BEB 19-11-12.
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
270 QC 3	3 pcs	11/29/19	0.00 0.00	Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DAS 13 2014 9-89
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
280 Packaging 1-1 - Pick Kit - B4B	3 pcs	11/29/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	

				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	PC
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
290	QC 4	3	11/29/19	0.00 0.00	Packaging 1 - 36
		pcs			QC 4 - 28
					QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
					QC 4 - 78
300	Packaging 3-1 - Stock - B4B	3	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
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				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS 78 NOV 29 2019
				Packaging 3 - 25 - B4B	9-89
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 NOV 29 2019
305 DC - 1 - B4B	3 pcs	11/29/19	0.00 0.00	DC - 1 - B4B	9-89
				DC - 2 - B4B	
310 QC 21 - FG	3 pcs	11/29/19	0.00 0.00	QC 21 - FG - 21	DAS 21 NOV 29 2019
				QC 21 - FG - 70	9-89
				QC 21 - SA - 53	

Part Op 130 - QC5- Inspect part completeness to step on W/O
 Descriptions: 140 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Bevel Fwd and Aft end for welding ***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***
 150 - QC9- Inspect visual per QSI004- Fusion Welds
 160 - QC5- Inspect part completeness to step on W/O
 170 - Chemical Conversion Coat per QSI005 4.1
 180 - QC7-Inspect Chemical Conversion Coat
 190 - Weld per dwg A/R Aluminum rod Batch: _____ - 1-Rivet Leg Assembly as per Dwg D2351
 220 - QC10- Inspect visual per QSI004- ground welds
 230 - QC5- Inspect part completeness to step on W/O
 240 - Chemical Conversion Coat per QSI005 4.1
 250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 260 - Wing Walk as per dwg QSI005 4.4 Batch: 5209364
 270 - QC3- Inspect Part Finish
 280 - Pick Kit
 290 - QC4- 100% Inspect kits for completeness
 300 - Identify and pack for shipping as per PPP D350-591-121
 305 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005
 310 - QC21- Final Inspection - Work Order Release - 3-Do not Grind top edge Flush

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2850-2	End Cap	3 pcs (1 ea)	140-Large Fab - Welded Assy-2- B4B	③ 5065609/5199770 ①
D2582	Hi-Skid Step Leg Assembly	3 pcs (1 ea)	190-Large Fab - Welded Assy-3- B4B	5210377
D2673-34	End Plate	3 pcs (1 ea)	190-Large Fab - Welded Assy-3- B4B	① 592727/5210765 ②
MS20600-AD4W3	Cherry Rivet	48 Ea (16 ea)	190-Large Fab - Welded Assy-3- B4B	5196544
AN3-37A	Bolt	6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5210648
AN4-13A	Bolt	3 Ea (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225690
AN4-16A	Bolt	6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225325
D2200-1	Mounting Lug	3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225193
D2200-3	Mounting Lug	3 pcs (1 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225226
D2732-030	Rubber Cushion - 3"	6 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5229980
MS21042L4	Nut	6 Ea (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5218152
MS21042L4	Nut	9 Ea (3 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225610
NAS1149D0363J	Washer	12 Ea (4 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225336
NAS1149D0463J	Washer	18 Ea (6 ea)	280-Packaging 1-1 - Pick Kit - B4B	5225595

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Welded Assy-2- B4B	D2850-2	3	14	0
	D2582	3	6	0
	D2673-34	3	44	0
	MS20600-AD4W3	48	322	0
280-Packaging 1-1 - Pick Kit - B4B	AN3-37A	6	121	0
	AN4-13A	3	1,867	0
	AN4-16A	6	379	0
	D2230-1	3	146	0
	D2230-3	3	393	0
	D2732-030	6	56	0
	MS21042L3	6	2,602	0
	MS21042L4	9	5,763	0
	NAS1149D0363J	12	1,320	0
	NAS1149D0463J	18	7,696	0
Part Specifications				
Specifications could not be found.				

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